

Ship July 27

Work Order ID 135018

135018

Page 1

July 24, 2015 11:01:29 AM

Item ID: D350-836-019 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Antenna Mount AS350 / AS355
 Start Date: 7/24/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/27/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SA Date: 20150724 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
GA202-1	A	JA

100 Document Control 0.00
 100
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and create labels as per PPP D350-836-019 CH001

DAS
02
9-89

JUL 27 2015

110 Pick Kit 0.00
 110
 Packaging Memo 0.00
 Packaging

① J.A. 27 9-89 JUL 24 2015

120 QC4- 100% Inspect kits for completeness 0.00
 120
 QC Memo 0.00
 Quality Control

DAS
02
9-89

JUL 27 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 135018

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Item ID: D350-836-019

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Antenna Mount AS350 / AS355

Stop ***NS2***

Start Date: 7/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/27/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130								DAS	
Packaging	Memo	0.00						02	
Packaging	Identify and pack for shipping as per PPP D350-836-019							360	JUL 27 2015
	Location: <u>Sold</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

15/7/27 *[Signature]*
mf
15-7-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 135018

135018

Parent Item: D350-836-019

D350-836-019

Parent Item Name: Crosstube Antenna Mount AS350 / AS355

Start Date: 7/24/2015

Required Date: 7/27/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.07.18 AS PER ECN13-561 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4853-1

Manufactured

No

Each

3.0000

1

D4853-1

JA

Top Bracket (Replaces P/N G13013-1)

DAS
02
9-89

Location

Loc Qty

Loc Code

ST519

3

126143

3

D4854-1

Manufactured

No

Each

12.0000

1

D4854-1

JA

Lower Bracket (Replaces P/N G13013-2)

DAS
02
9-89

Location

Loc Qty

Loc Code

st526

12

109079

2

126502

10

D4855-1

Manufactured

No

Each

12.0000

1

D4855-1

JA

Antenna Bracket (Replaces P/N G13013-3)

DAS
02
9-89

Location

Loc Qty

Loc Code

st526

12

126143

6

128258

6

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

JUL 24 2015

Picklist Print

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Work Order ID: 135018

135018

Parent Item: D350-836-019

D350-836-019

Parent Item Name: Crosstube Antenna Mount AS350 / AS355

Start Date: 7/24/2015

Required Date: 7/27/2015

Start Qty: 1.00

Required Qty: 1.00

D2732-030

Manufactured No

Each

84.0000

2

***D2732-030* ***

Rubber Cushion - 3"

Qty 2X

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

2

117118

2

134608

36

ST410

46

133074

46

117118

AN4-16A

Purchased

No

~~8117706~~

Each

168.0000

2

2

AN4-16A

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

ST343

163

M132317

163

AN4-11A

Purchased

No

Each

80.0000

2

AN4-11A

BOLT

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

20

120731

20

ST325A

60

M128362

60

NAS1149D0432J

Purchased

No

Each

695.0000

8

NAS1149D0432.I

WASHER

DAS
02
9-89

Location

Loc Qty

Loc Code

ST269

695

m131026

695

**

JA

JUL 24 2015

DAS
27
9-89

DAS
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9-89

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 135018

135018

Parent Item: D350-836-019

D350-836-019

Parent Item Name: Crosstube Antenna Mount AS350 / AS355

Start Date: 7/24/2015

Required Date: 7/27/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

3,392.000

4

MS21042L 4

Locknut

JA

JUL 24 2015

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

142

m127813

142

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

3078

m128300

8

m128798

12

m130388

7

m130922

97

m131618

12

m132123

56

m132382

2886

4

REFERENCE ONLY**DAS
02
9-89****DART AEROSPACE USA, INC.****GA202-1**
Page 7 of 7**5. PARTS LIST**

Qty -019	Qty -111	Part Number	Description
X		D350-836-019	CROSSTUBE ANTENNA MOUNT KIT AS350/355 (P162-350)
	X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
	1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
	1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
	1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
	1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	AN4-16A	BOLT
2	2	AN4-11A	BOLT
8	8	NAS1149D0432J	WASHER
4	4	MS21042L4	LOCKNUT

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Revision: **A**
Date: 13.05.15

Work Order ID 135018

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135018

Page 1

Item ID: D350-836-019

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Crosstube Antenna Mount AS350 / AS355

Stop *NS2*

Start Date: 7/24/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/27/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: SH Date: 20150724 Tooling: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
GA202-1	A

JA

100	Document Control	0.00
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100

DC

Memo 0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D350-836-019 CH001

SH 20150724

110	Pick Kit	0.00
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110

Packaging

Memo 0.00

Packaging

① JA JUL 24 2015

120	QC4- 100% Inspect kits for completeness	0.00
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120

QC

Memo 0.00

Quality Control